

Work Order ID 64273

Wednesday, December 01, 2010 11:46:38 A

Page 1

Item ID: D3907-1

Accept

Revision ID:

Item Name: Bushing

Start Date: 12/1/2010 Start Qty: 40.00

Required Date: 12/8/2010 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:

Date: 10/2/1

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3907

A

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

Machine as per Folio FA823
& Dwg D3907

Dwg Rev: A

folio Rev: A

Deburr

SD 10/1/04

40 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

SD 11/1/04

40 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 64273

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Page 2

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Revision ID:

Item Name: Bushing

Start Date: 12/1/2010 Start Qty: 40.00

Required Date: 12/8/2010 Req'd Qty: 40.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

*****STOCK IN BASKET CELL*****

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup Start

Stop



11.1.4

40

11.01.06

11/01/06
11/01/06

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, December 01, 2010 11:46:49 AM

Page 1

Work Order ID: 64273

Parent Item: D3907-1

Parent Item Name: Bushing




Start Date: 12/1/2010

Required Date: 12/8/2010

Start Qty: 40.00

Required Qty: 40.00

Comments:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304R0.375  304 ROUND BAR 0.375 | | Purchased | No | | | 100 | f | 30.4085 | 0.03 | 1.2 | | | |



SA

11/01/04

| Location | Loc Qty | Loc Code |
|----------|-----------------|----------|
| MAT | 25.0685 | |
| 111323 | 5.1 | |
| 114467 | 5.1 | |
| 114676 | 1.7 | |
| 115180 | 1.7 | |
| 115334 | 17.1685 | |
| MAT029 | 5.34 | |
| 113325 | 5.85 | |
| 114356 | 1.49 | |

1.25 Pt

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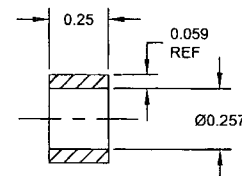
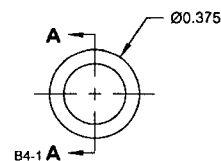
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 64273
BS10-12-1



D3907-1 BUSHING

SECTION A-A C5-1

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

OR: AISI 304/316 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
Chatterbox

| A | | NEW ISSUE | | DESCRIPTION | | AJS | 09.03.11 |
|------------|--|-----------|--|--|--|--------------|----------|
| REV. | | | | | | BY | DATE |
| DESIGN | | AJS | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | |
| DRAWN | | AJS | | | | | |
| CHECKED | | | | DRAWING NO. | | REV. A | |
| MFG. APPR. | | | | D3907 | | SHEET 1 OF 1 | |
| APPROVED | | | | TITLE | | SCALE | |
| DE APPR. | | | | BUSHING (BASKET REPAIR) | | NTS | |
| DATE | | 09.03.11 | | COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES OF THE CONTRACT ONLY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD. | | | |

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